



5/21

DART AEROSPACE LTD		Work Order:	23160
Description: Dual Disabling Kit (Light Bell)		Part Number:	D206-739-011 D3370-041
		Keyed:	<input checked="" type="checkbox"/> Alike <input type="checkbox"/> Unalike
Dwg: D3369 Rev. A1 page 4; D3370 Rev. B; D3393 Rev. A page 1		Qty:	10
		Page 1 of 3	

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	AR	05/05/10	10																				
2	DC	Photocopy bluefile and create labels per PPP D206-739-011 CHG002 WK19 AL	DH	05.05.26	10																				
3	GA	Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2728-7</td> <td>Decal</td> <td></td> </tr> <tr> <td>1</td> <td>D3373-1</td> <td>Cam Lock</td> <td></td> </tr> <tr> <td>1</td> <td>D3393-1</td> <td>Battery Lock Casing</td> <td></td> </tr> <tr> <td>1</td> <td>D3393-3</td> <td>Cam Lock Shaft</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal		1	D3373-1	Cam Lock		1	D3393-1	Battery Lock Casing		1	D3393-3	Cam Lock Shaft				
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal																							
1	D3373-1	Cam Lock																							
1	D3393-1	Battery Lock Casing																							
1	D3393-3	Cam Lock Shaft																							
4	GA	Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.																							
5	GA	Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5																							
6	GA	Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3369-5</td> <td>Washer</td> <td></td> </tr> <tr> <td>2</td> <td>5/16WC</td> <td>SS Flat Washer</td> <td></td> </tr> <tr> <td>A/R</td> <td>N/A</td> <td>262 Locktite</td> <td></td> </tr> </tbody> </table> Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly. Record the Key Number on page 3	Qty	Part Number	Description	Batch	1	D3369-5	Washer		2	5/16WC	SS Flat Washer		A/R	N/A	262 Locktite								
Qty	Part Number	Description	Batch																						
1	D3369-5	Washer																							
2	5/16WC	SS Flat Washer																							
A/R	N/A	262 Locktite																							
7	WS	Tack Weld lock shaft to flat cam Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>A/R</td> <td>N/A</td> <td>SS Rod</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	A/R	N/A	SS Rod																
Qty	Part Number	Description	Batch																						
A/R	N/A	SS Rod																							
8	WS	Apply crazy glue to caps then press caps into body. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>9567K21</td> <td>Polyethelene Cap</td> <td></td> </tr> <tr> <td>A/R</td> <td>N/A</td> <td>Krazy Glue</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2	9567K21	Polyethelene Cap		A/R	N/A	Krazy Glue												
Qty	Part Number	Description	Batch																						
2	9567K21	Polyethelene Cap																							
A/R	N/A	Krazy Glue																							
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask Dowel Pins Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3370-1</td> <td>Pedal Lock Base</td> <td>B 22285 A</td> </tr> <tr> <td>1</td> <td>D3370-3</td> <td>Pedal Lock Cover</td> <td>B 22286 A</td> </tr> <tr> <td>1</td> <td>D3385-1</td> <td>Hinge</td> <td>B 22271 B 22287</td> </tr> </tbody> </table> Identify as D3370-051	Qty	Part Number	Description	Batch	1	D3370-1	Pedal Lock Base	B 22285 A	1	D3370-3	Pedal Lock Cover	B 22286 A	1	D3385-1	Hinge	B 22271 B 22287	SB	05/05/11	10				
Qty	Part Number	Description	Batch																						
1	D3370-1	Pedal Lock Base	B 22285 A																						
1	D3370-3	Pedal Lock Cover	B 22286 A																						
1	D3385-1	Hinge	B 22271 B 22287																						
10	QC3	Inspect Powder Coat	SB	05/05/11	10																				

RELEASED
10/05/01/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-05-11	11	Hinge D3385-5 doesn't exist. Use hinge D3385-1 for this batch. Hinge soon to be replaced by D3385-3.	SB05/05/11		N/A		 05-05-11

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-05-11	11							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

5/21

DART AEROSPACE LTD		Work Order:	23160
Description: Dual Disabling Kit (Light Bell)		Part Number:	D206-739-011
		Keyed:	<input checked="" type="checkbox"/> Alike <input type="checkbox"/> Unalike
Dwg: D3369 Rev. A1 page 4; D3370 Rev. B; D3393 Rev. A page 1		Qty:	10
		Page 2 of 3	

Step	Location	Procedure	By	Date	Qty																				
11	GA	Press dowel pins into D3370-3 pedal lock cover, then assemble hinge as per Dwg D3370. Apply locktite 262 to 7/8" nut. M16507 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2728-7</td><td>Decal</td><td>B22554</td></tr><tr><td>1</td><td>D3373-5</td><td>Cam Lock</td><td>B22477</td></tr><tr><td>4</td><td>AN526C832R6</td><td>Screw</td><td>M16612</td></tr><tr><td>3</td><td>238-028</td><td>Ø3/16" Dowel Pin 1/2" long</td><td>M16988</td></tr></table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal	B22554	1	D3373-5	Cam Lock	B22477	4	AN526C832R6	Screw	M16612	3	238-028	Ø3/16" Dowel Pin 1/2" long	M16988	SB	05/05/11	10
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal	B22554																						
1	D3373-5	Cam Lock	B22477																						
4	AN526C832R6	Screw	M16612																						
3	238-028	Ø3/16" Dowel Pin 1/2" long	M16988																						
12	GA	Open D3373-5 lock package. Keep keys, lock body, lock body nut, screw, offset cam and lock barrel. Discard the rest.	SB	05/05/11	10																				
13	GA	Fabricate D3373-5 Cam Lock as per Dwg D3370 Identify as D3373-5	SB	05/05/11	10																				
14	GA	Assemble lock mechanism and cam and install decal as per Dwg D3370	SB	05/05/11	10																				
15	GA	Assemble lanyard to cyclic sock as per Dwg D3384 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3384-1</td><td>Cyclic Sock</td><td>B22340</td></tr><tr><td>2</td><td>CBL-460</td><td>Loop Sleeve</td><td>M16713</td></tr><tr><td>24"</td><td>CBL-1240</td><td>Cable</td><td>M16713</td></tr></table> Identify as D3384-041	Qty	Part Number	Description	Batch	1	D3384-1	Cyclic Sock	B22340	2	CBL-460	Loop Sleeve	M16713	24"	CBL-1240	Cable	M16713	SB	05/05/11	10				
Qty	Part Number	Description	Batch																						
1	D3384-1	Cyclic Sock	B22340																						
2	CBL-460	Loop Sleeve	M16713																						
24"	CBL-1240	Cable	M16713																						
16	GA	Assemble D3384-041 to D3370-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3370. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>AN960-416</td><td>Washer</td><td>M5519</td></tr><tr><td>1</td><td>HX-81</td><td>1/4"-20 SHCS 3/8" long</td><td>M16971</td></tr></table> Identify as D3370-041 & attach keys Record the Key Number on page 3	Qty	Part Number	Description	Batch	2	AN960-416	Washer	M5519	1	HX-81	1/4"-20 SHCS 3/8" long	M16971	SB	05/05/11	10								
Qty	Part Number	Description	Batch																						
2	AN960-416	Washer	M5519																						
1	HX-81	1/4"-20 SHCS 3/8" long	M16971																						
17	QC5	Inspect work to Step 15	2	05-05-12	10																				
18	PK	Ensure that keys are attached to D3370-041 and D3393-041 Pick: IDENTIFY + STALL <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3370-041</td><td>Pedal Lock Assembly</td><td>B23160</td></tr><tr><td>1</td><td>D3393-041</td><td>Battery Lock Assembly</td><td></td></tr></table> Ensure that keys can be locked and unlocked for each D3370-041 and D3393-041 assembly.	Qty	Part Number	Description	Batch	1	D3370-041	Pedal Lock Assembly	B23160	1	D3393-041	Battery Lock Assembly		CY	05/05/16	10								
Qty	Part Number	Description	Batch																						
1	D3370-041	Pedal Lock Assembly	B23160																						
1	D3393-041	Battery Lock Assembly																							
19	QC4	Inspect Kit 100% for Completeness on the W/O																							
20	PK	Identify and pack for shipping as per PPP D206-739-011																							
21	AC	Cost / part: 46.13	Set	05.06-23	10																				
22	DC	Close W/O 37.25 Inspect Level 21		05.07.04	10																				

RELEASED
7/11/05 04:20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

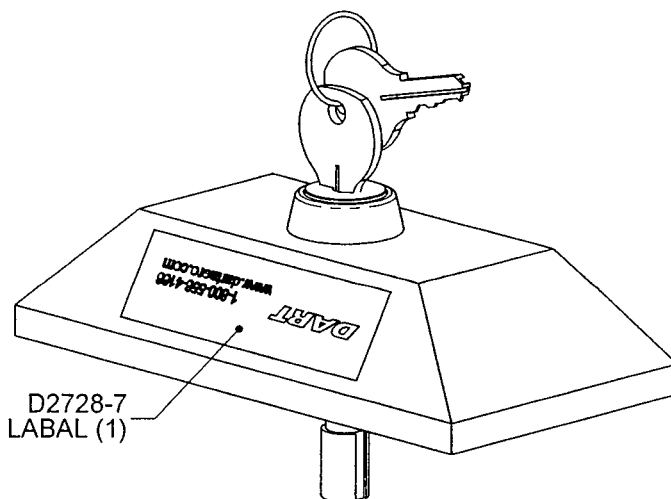
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



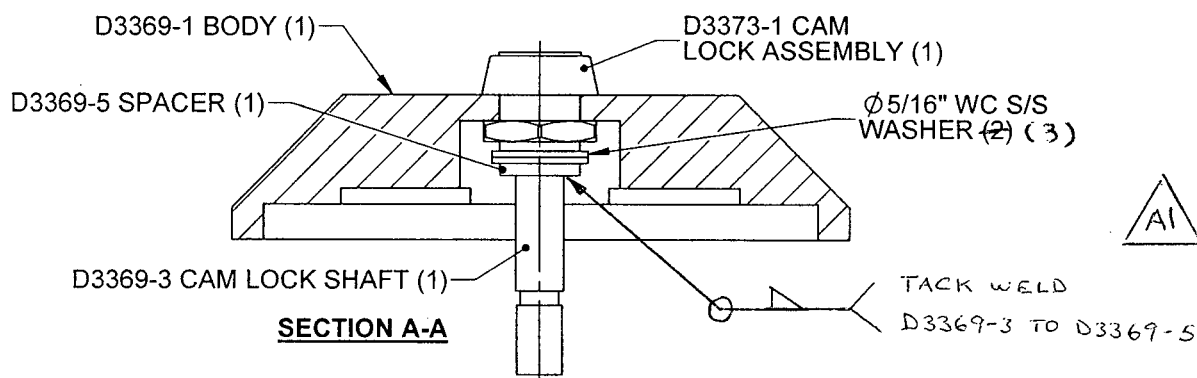
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CHECKED R	APPROVED MS	DRAWING NO. D3369	REV. A SHEET 1 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 1:1.5
A	04.12.16	NEW ISSUE	



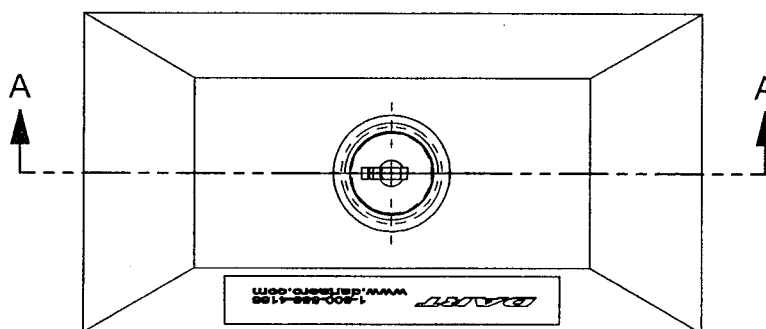
D2728-7
LABAL (1)

BATTERY LOCK SHOWN LOCKED WITH KEY

RELEASED
05/02/11



SECTION A-A



D3369-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004

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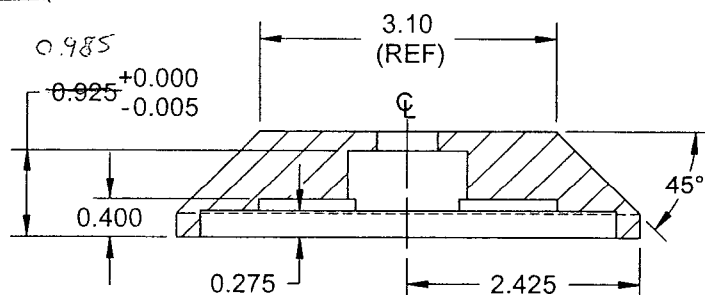
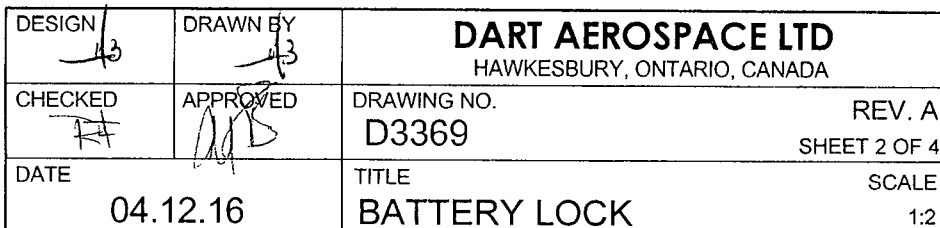
NO. 23160

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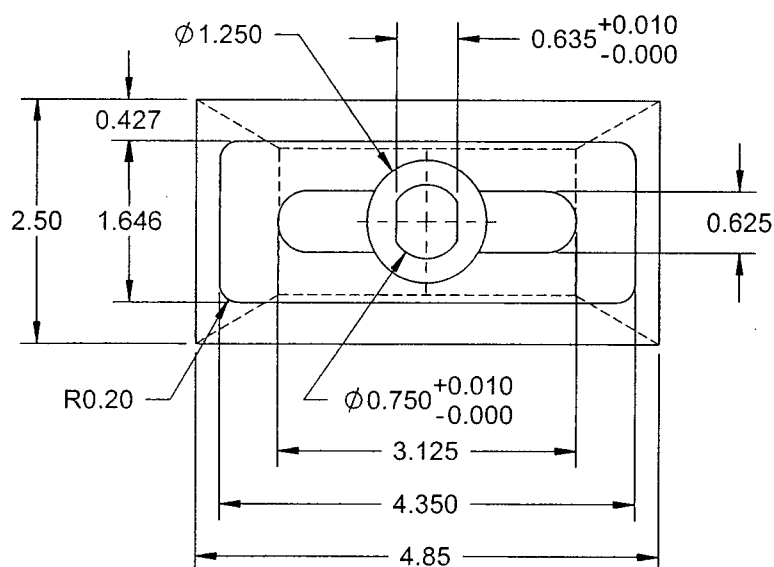
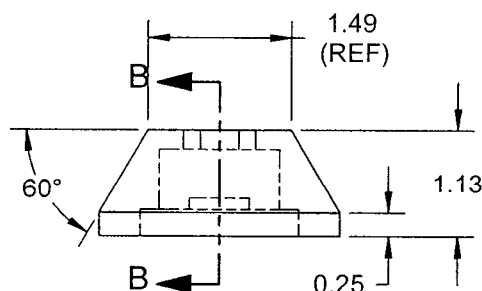
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ADD TACK WELD
0.865 WAS 0.925

A1 11/5 05.02.11



SECTION B-B



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05/02/11

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NO. 23160

D3369-1 BODY

NOTES:

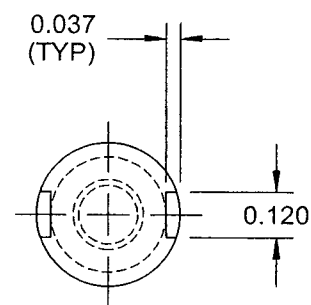
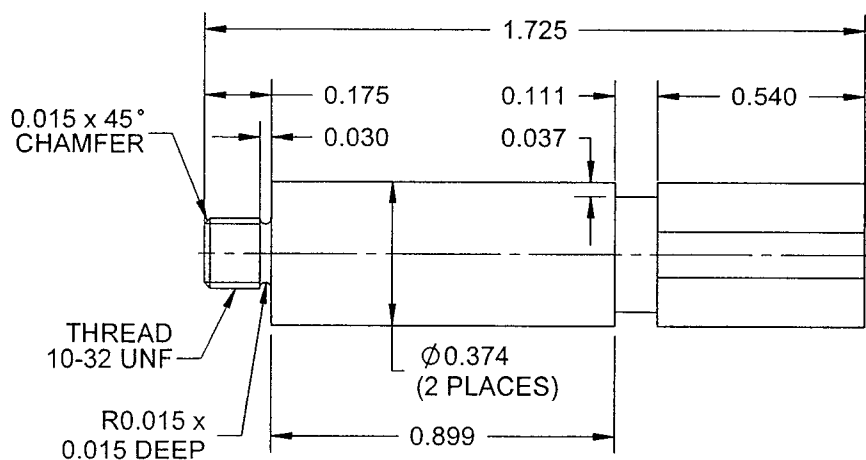
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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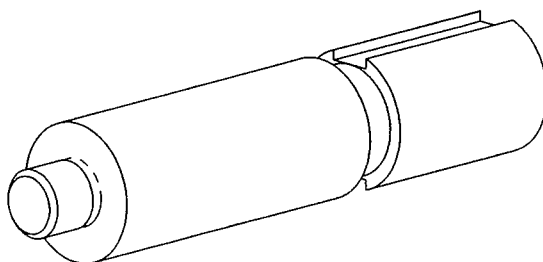
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CHECKED <i>14</i>	APPROVED <i>105</i>	DRAWING NO. D3369	REV. A SHEET 3 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1



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105
85/02/11



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WORK ORDER
NO. 23160

D3369-3 CAM LOCK SHAFT

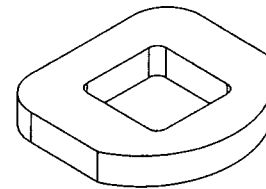
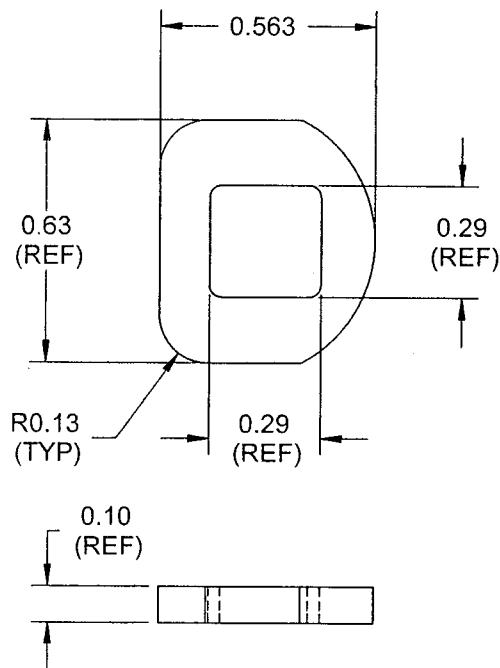
NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



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DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



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05/02/11

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WORK ORDER

NO. 023160

-5
D3369 SPACER



NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



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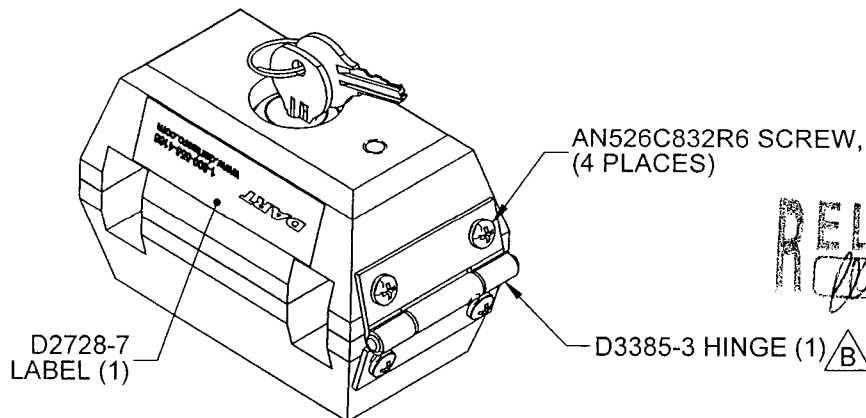
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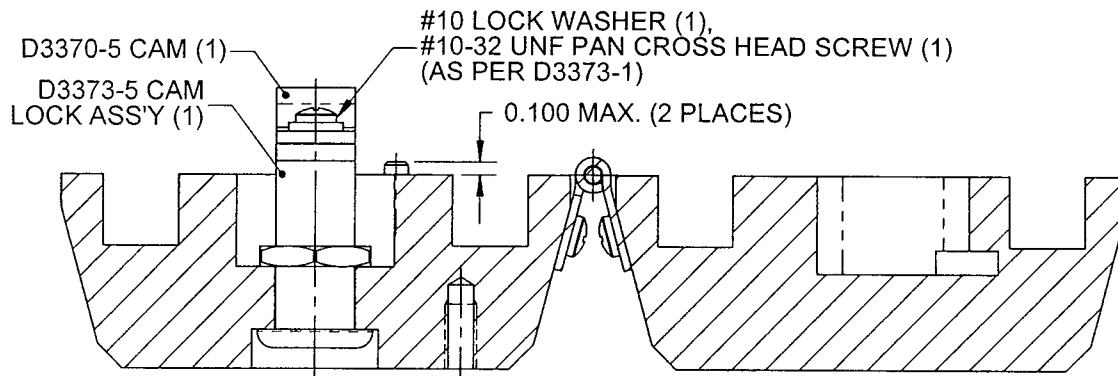
WORK ORDER

NO. 23160

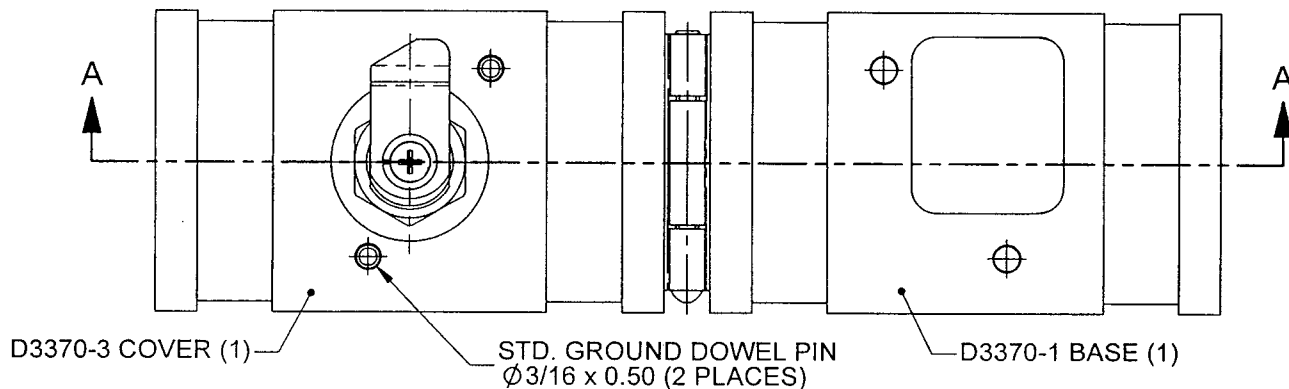
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3370	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:1.5
A	04.12.15	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



PEDAL LOCK SHOWN LOCKED WITH KEY



SECTION A-A



D3370-051 PEDAL LOCK ASSEMBLY

NOTES:

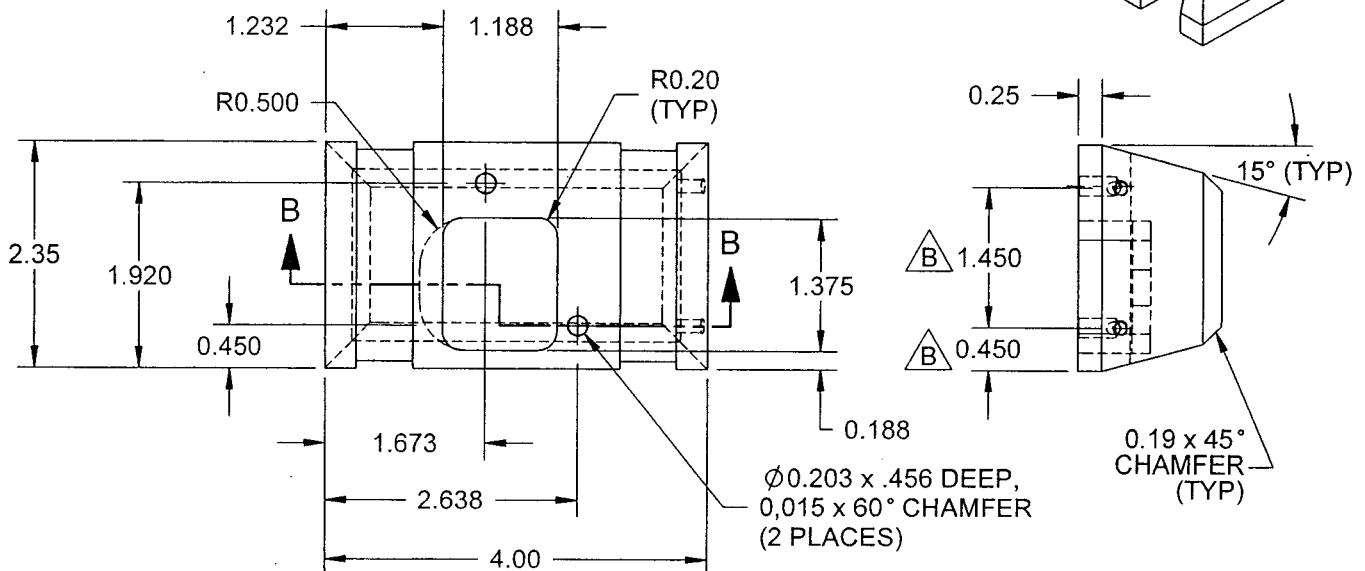
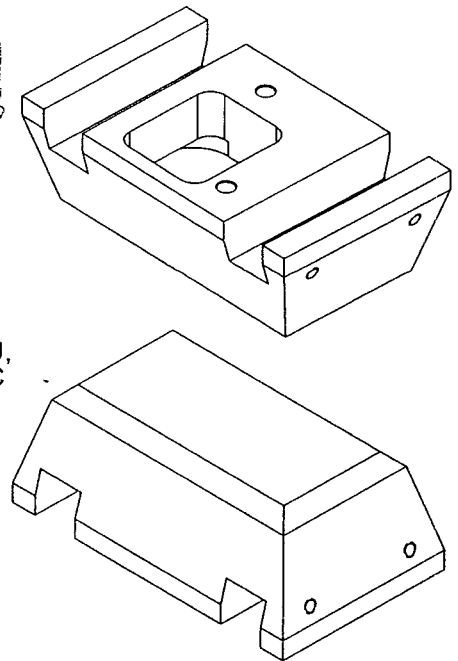
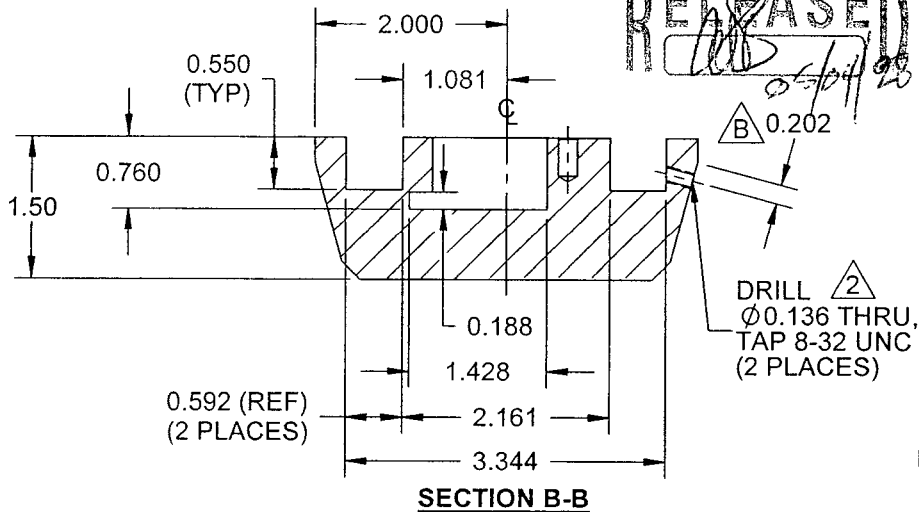
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 77	APPROVED 13	DRAWING NO. D3370	REV. B SHEET 2 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



D3370-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER

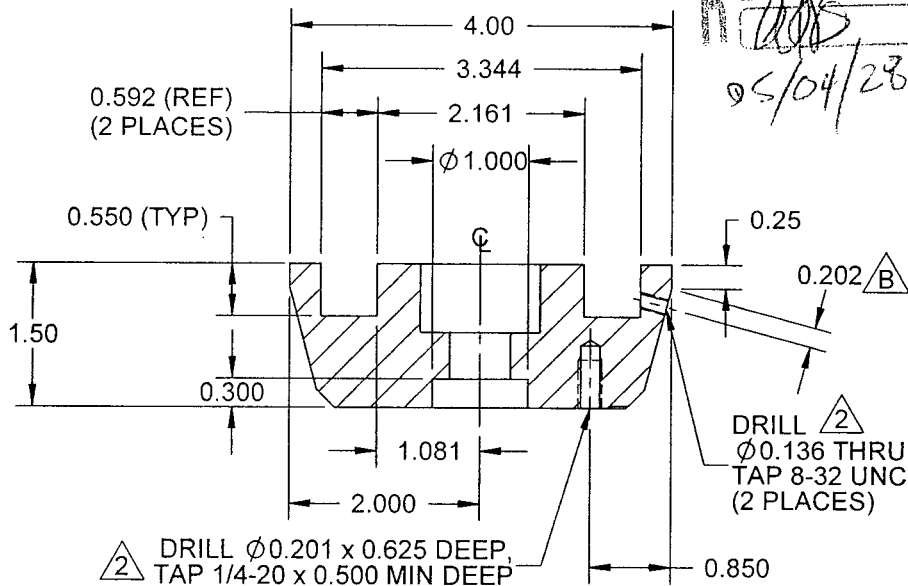
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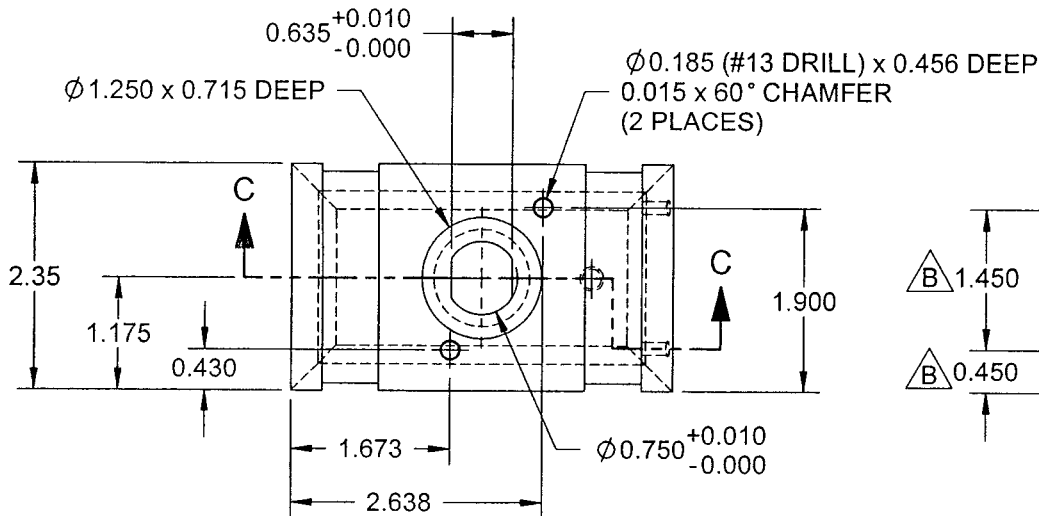
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3370	REV. B SHEET 3 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



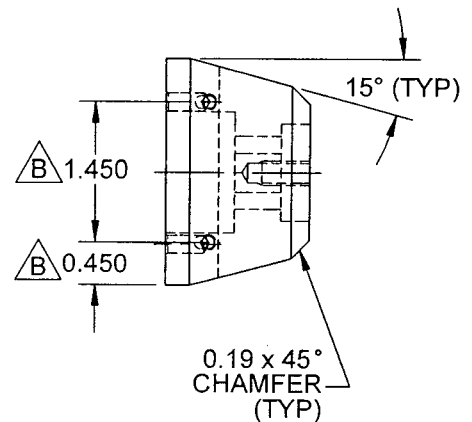
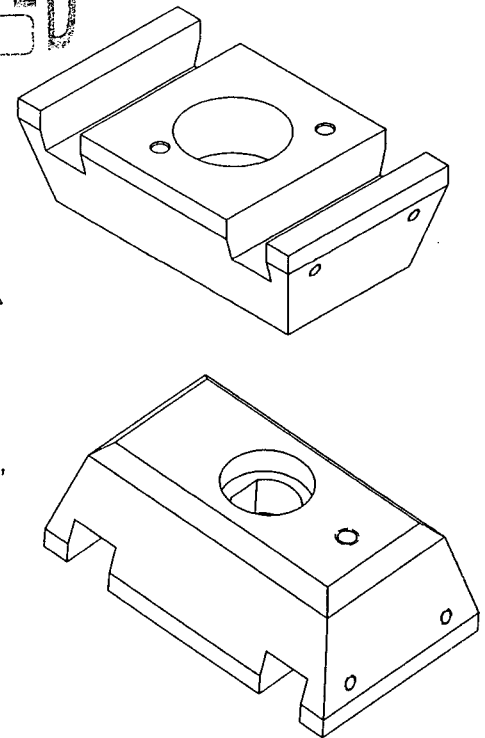
SECTION C-C



D3370-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010



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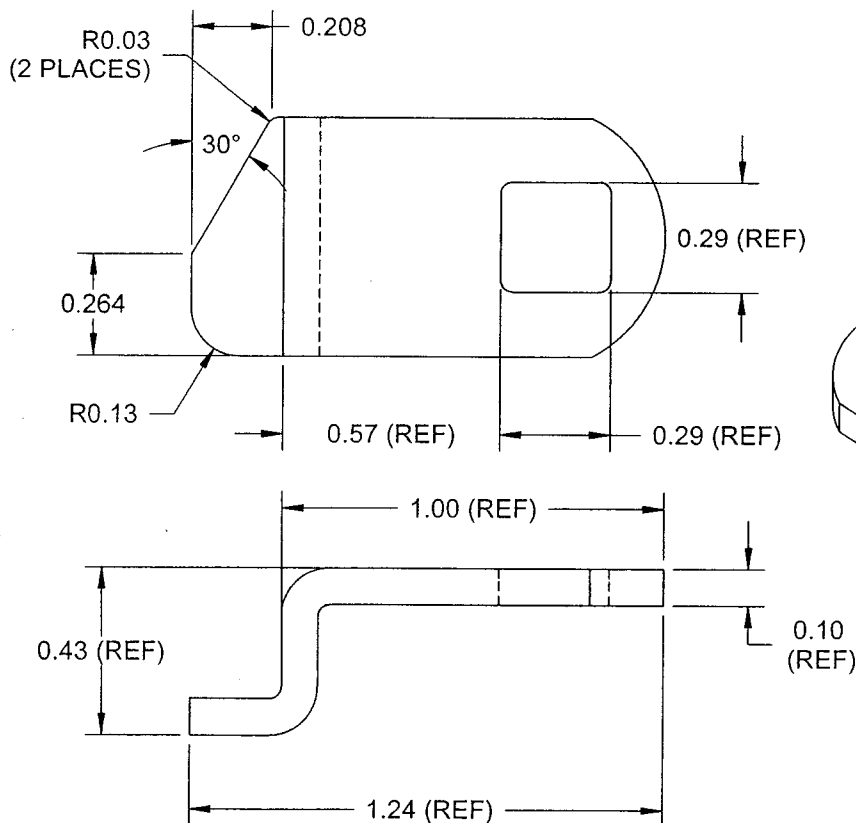
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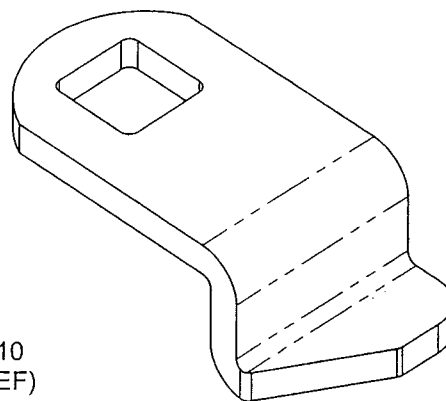


DESIGN #3	DRAWN BY #3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #3	APPROVED #3	DRAWING NO. D3370	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



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05/04/28



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NO. 23160

D3370-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



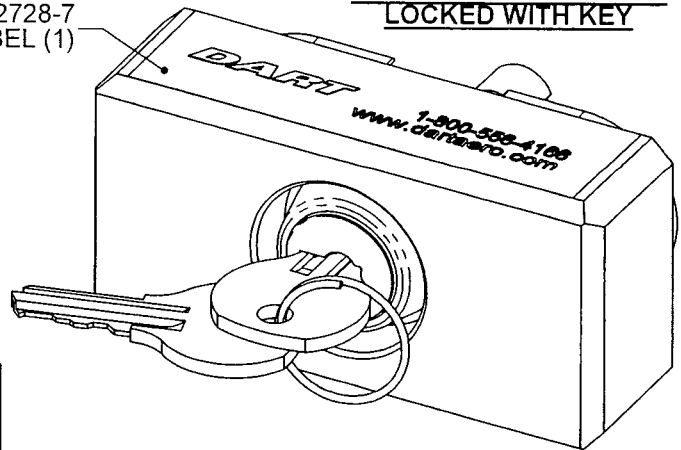
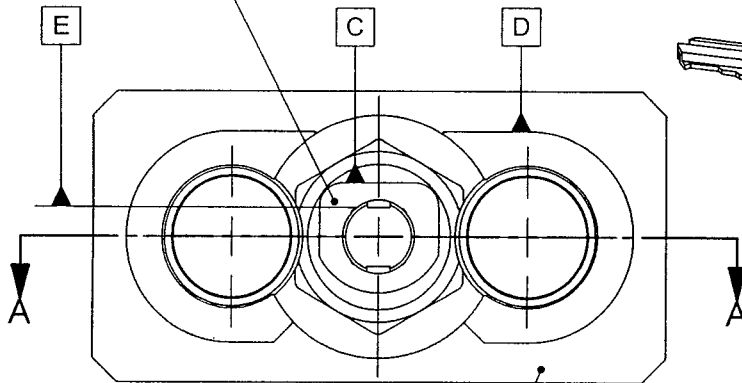
DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RT	APPROVED AKS	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
05/03/09

D2728-7
LABEL (1)

**BATTERY LOCK SHOWN
LOCKED WITH KEY**

POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWN



D3373-1
CAM LOCK
ASSEMBLY (1)

D3393-1
CASING (1)

Ø5/16" WC S/S
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2) Δ
AND APPLY KRAZY GLUE

0.09^{+0.03}
-0.01 (2 PLACES)

D3393-3 CAM
LOCK SHAFT (1)

TACK WELD
D3393-3 TO D3369-5

SECTION A-A

D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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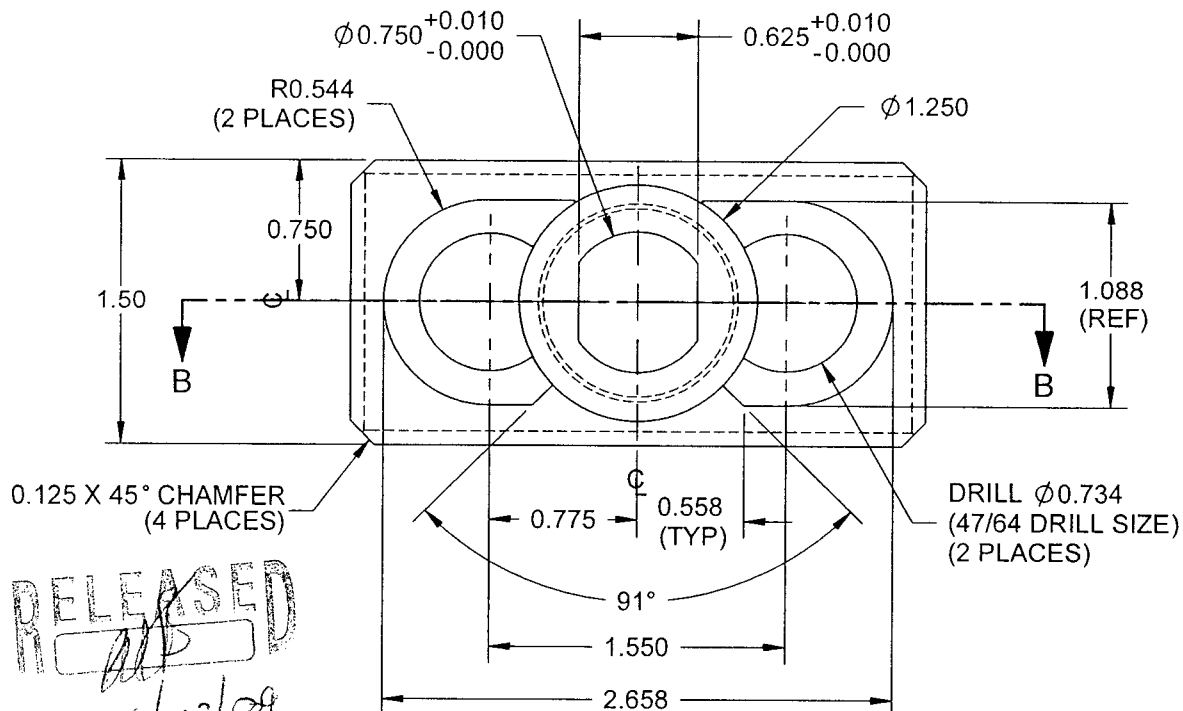
NO. 23160

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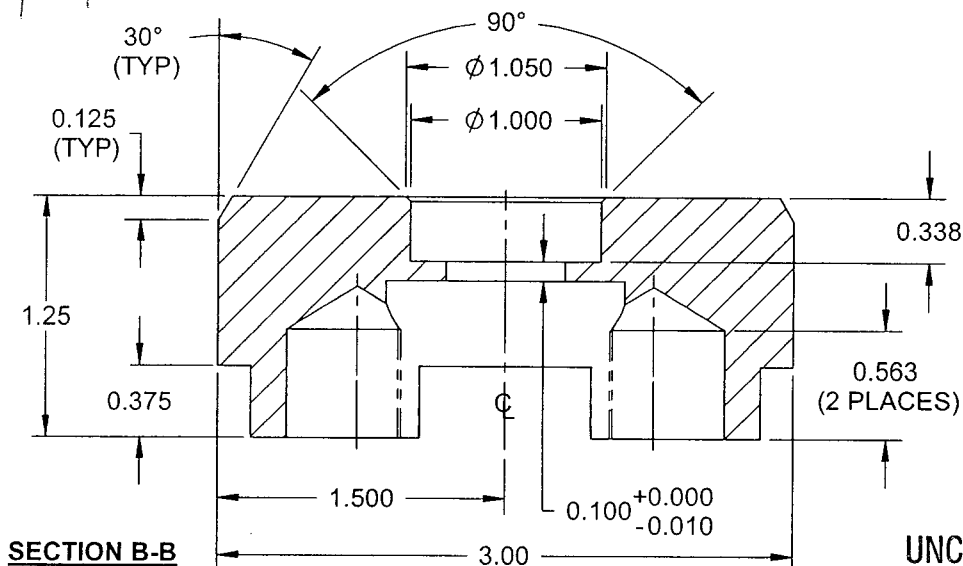
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09	TITLE BATTERY LOCK		SCALE 1:1



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05/03/09



SECTION B-B

D3393-1 CASING

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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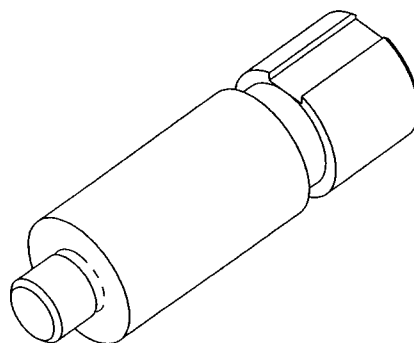
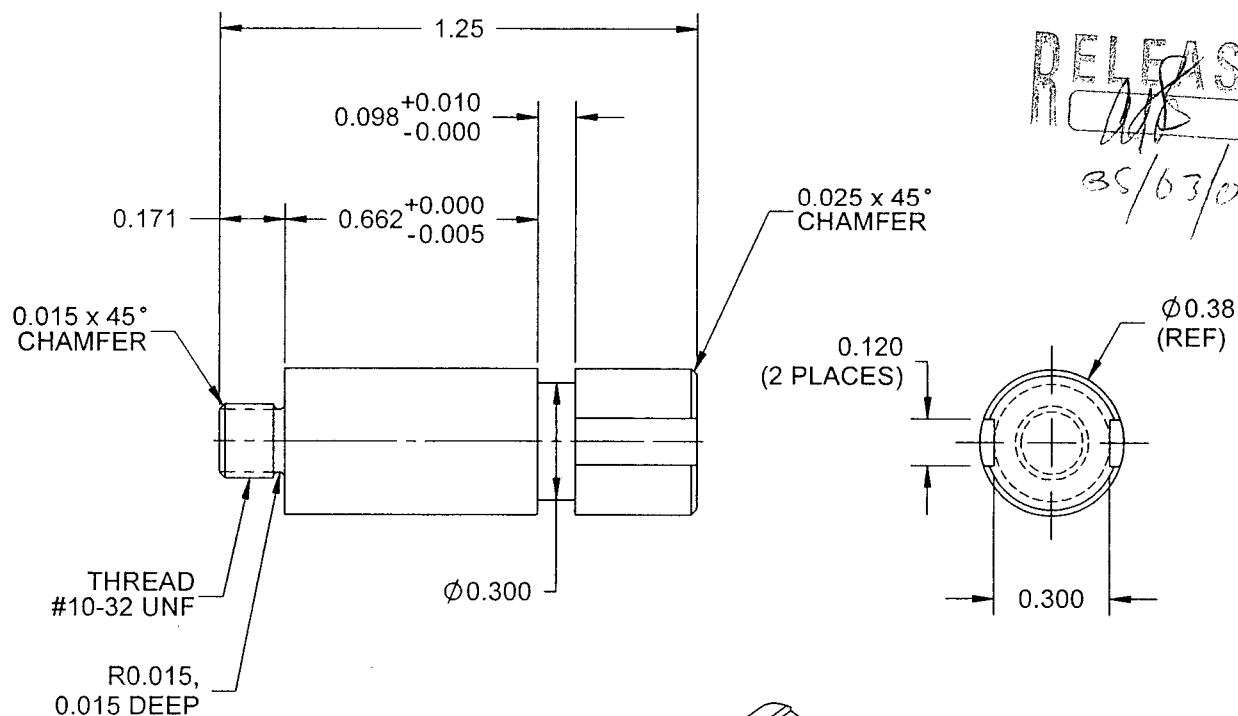
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DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



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NO. 23160

D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 06, 2005
09:55 am

Work Order No : 0023160
Project Name : D206-739-011
Project For : WK521
Work Order Type : Main
Main WO Number :
House Part Number : *D206-739-011
Description : Dual Disabling Kit
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 05-04-05
Est Finish Date : 05-26-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00